

Date: Monday, 17/07/2006 2:59:12 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 27927	
Estimate Number : 10670	
P.O. Number : N/A	Part Number : D2924
This Issue : 17/07/2006 S.O. No. : N/A	Drawing Number : D2924 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 27927	Material : N/A
	Due Date : 24/07/2006
Written By : <u> </u>	Qty: <u>22</u> Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: B 02.10.24 Re-format KJ	
Est: C 06.07.17 waterjetEC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010S20GA

1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8222 sf(s)/Unit Total : 16.4430 sf(s)

1010/1025/A21/6aA SHEET B# M101463

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2924

Dwg Rev: AProg Rev: A

2-Deburr if necessary

M.F.
SAD06/08/04
06:08:0322
22

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: DIMENSIONAL CHECK

SAD

06:08:03

22

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06.08.04

22

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27927

Part Number: D2924

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr and form on brake using DT8326 and DT8261 as per Dwg D2577

SB 01/08/07 22

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 06 09 07 22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/09/07 (22)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DL 06/09/07 (22)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/09/07 (22)

Job Completion



DL 06/09/07

Date: Friday, 14/07/2006 1:13:40 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	27927		
Estimate Number :	10670		
P.O. Number :		Part Number :	D2924
This Issue :	14/07/2006	Drawing Number :	D2924 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	A
Previous Run :		Material :	
Written By :		Due Date :	30/07/2006
Checked & Approved By :		Qty:	20
Comment :	Est: B 02.10.24 Re-format KJ	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

Laser Cut per Dwg D2924 flat pattern D2924

Material release note required

water jet

2.0	D2924F	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2924T1

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr and form on brake using DT8326 and DT8261 as per Dwg D2577

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 14/07/2006 1:13:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27927

Part Number: D2924

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

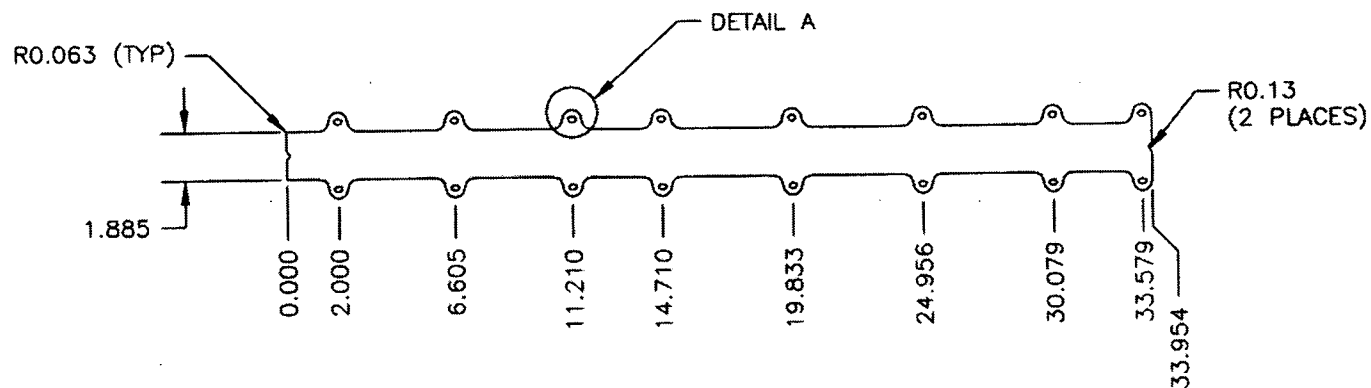
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

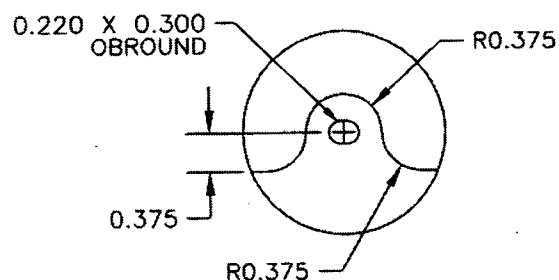
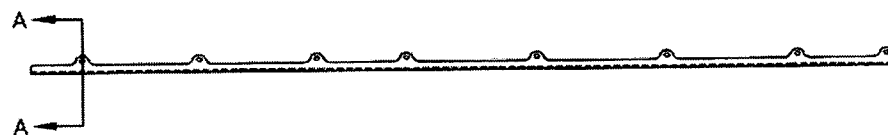
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

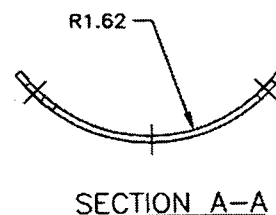
FLAT PATTERN



BENDING DETAIL



DETAIL A



MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

RELEASED
 00.05.11

DART



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED	RF	APPROVED	RF	BELLEVEUE, WA
DATE	99.10.14	TITLE	WEARSHOE	REV. A
A	99.10.14	NEW ISSUE	1:7	SHEET 1 OF 1

DART AEROSPACE LTD		Work Order: 27927
Description: WEARSHOE		Part Number: D2924
Inspection Dwg: D2924 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	± 0.010	1.890	✓		Vertical Vern	
2.000	± 0.010	1.996	✓		Vertical Vern	
6.605	± 0.010	6.609	✓		Vertical Vern	
11.210	± 0.010	11.205	✓		measuring tape and Vern	
14.710	± 0.010	14.707	✓		measuring tape and Vern	
19.833	± 0.010	19.827	✓		measuring tape and Vern	
24.956	± 0.010	24.960	✓		measuring tape and Vern	
30.079	± 0.010	30.075	✓		measuring tape and Vern	
33.579	± 0.010	33.575	✓		measuring tape and Vern	
6.220	± 0.010	0.213022	✓		Vern	
0.300	± 0.010	0.2950303	✓		Vern	
0.375	± 0.010	0.378	✓		Vertical Vern	
R0.375	± 0.010	R0.375	✓		R-G	
R0.375	± 0.010	R0.375	✓		R-G	
R0.065	± 0.010	R0.065	✓		R-G	
R0.13	± 0.030	R0.13	✓		R-E	
33.954	± 0.010	33.950	✓		measuring tape	
0.040	± 0.010	0.038	✓		Vern	

Measured by: SAA	Audited by: [Signature]	Prototype Approval:
Date: 06:08:03	Date: 06-08-14	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	